

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026670**Date Inspected:** 08-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 11W PP104 W4 Lifting Lug Hole #4 (Exterior)
2. 11W PP103 W3 Lifting Lug Holes #2 and 4 (Exterior)
3. 14W PP128 W4 Lifting Lug Hole #1 (Exterior)

1. 11W PP104 W4 Lifting Lug Hole #4 (Exterior)

The QA inspector made random observations of ABF welder Jorge Lopez, ID# 6149 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #4 located at 11W PP104 W4. The QA inspector observed QC inspector Sal Merino monitoring the progress to ensure the welding parameters was in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=130). The QA inspector made subsequent observations throughout the shift to monitor quality. The QA inspector noted that the work on the exterior side of the LLH was completed on this date and appeared to be in general conformance with the contract documents.

2. 11W PP103 W3 Lifting Lug Hole #2 (Exterior)

The QA inspector randomly observed ABF welder Mike Jimenez ID# 4671 preheat the joint to 50°F prior to

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performing SMAW in the 1G flat position on LLH #2 located at 11W PP103 W3. The QA inspector observed the QC inspector identified as Sal Merino measure the joint fit-up and found it to be acceptable and within compliance. The QA inspector observed the QC inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=180). The QA inspector randomly observed the ABF welder grind and blend the start and stop areas of the weld throughout the joints depth. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work on the exterior side of the LLH was completed on this date and appeared to be in general conformance with the contract documents.

11W PP103 W3 Lifting Lug Hole #4

The QA inspector observed QC inspector Sal Merino measure the planar offset and the root gap of LLH #4 insert located at 11W PP103 W3 and verified that the results were in compliance. The QA inspector observed ABF welder Mike Jimenez ID #4671 preheat the joint to 50°F and began welding utilizing the SMAW method in the 1G flat position. The welder began with 1/8 inch diameter E7018H4R electrodes at 145 amperes for the root pass and the balance with 3/16 inch diameter electrodes at 190 amperes. The QA inspector observed the QC inspector monitoring the progress to ensure the welding parameters was in compliance pertaining to ABF-WPS-D15-1050A-CU. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

3. 14W PP128 W4 Lifting Lug Hole #1 (Exterior)

The QA inspector observed the QC inspector Pat Swain, verify the fit up of the joint and found it to be satisfactory. The QA inspector made random observations of ABF welder Jorge Lopez, ID# 6149 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #1 located at 14W PP128 W4. The QA inspector observed QC inspector monitoring the progress to ensure the welding parameters was in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=135). The QA inspector made subsequent observations throughout the shift to monitor quality. The QA inspector noted that the work on the exterior side of the LLH was in progress and appeared to be in general conformance with the contract documents.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer